

# Work Order ID 67753

Wednesday, March 30, 2011 10:13:26 AM



Page 1

Item ID:	D3650-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tunnel Top Panel Assembly					
Start Date:	3/30/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/1/2011	Req'd Qty:	2.00		Customer:	

## Reference:

Approvals:	Process Plan:	<u>H</u>	Date:	<u>11-03-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3650	Rev C								
100	Pick Kit	0.00							
	Packaging	Memo							
	Packaging								
110	Small Fab	0.00							
	Small Fab	Memo							
	Small Fab	1-Assemble as per dwg D3650□2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant□as per dwg D3650□Batch: <u>11 A6689</u>							
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	Memo							
	Quality Control								

8 11/03/31

8 11/03/31

(+2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67753**

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Page 2

Item ID: D3650-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tunnel Top Panel Assembly

Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

B 67752

0.00

SD

11/03/31

②

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31

mf  
11-03-31

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 67753

Parent Item: D3650-041

Parent Item Name: Tunnel Top Panel Assembly





Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-11-12 EC verified by: DD  
IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC  
IPP Rev:C Ecn 1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10	NAS1149C0363 R	Purchased	No			100	Each	0.0000	8	16			
						113889							
WASHER												4/02/31	
AN3C3A		Purchased	No			110	Each	156.0000	8	16			
												11/03/31	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				156					
				116704				52					
				117161				104				16	
D3650-1		Manufactured	No			110	Each	4.0000	1	2			
												11/03/31	
Aft Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST189				4					
				65544				4				2	
D3650-3		Manufactured	No			110	Each	4.0000	1	2			
												11/03/31	
Center Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST189				4					
				53842				1					
				65547				3				1	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Wednesday, March 30, 2011 10:13:33 AM

Work Order ID: 67753



Parent Item: D3650-041



Parent Item Name: Tunnel Top Panel Assembly

Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

D3650-5

Manufactured No

110

Each

3.0000

1

2



SA 4/02/31

Fwd Panel

Location

Loc Qty

Loc Code

ST189

3

65545

3

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

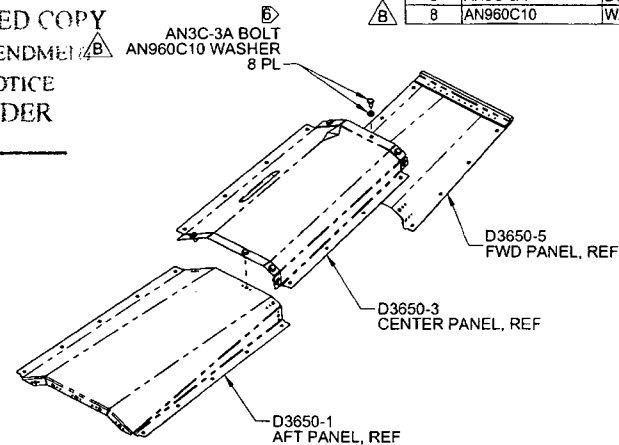
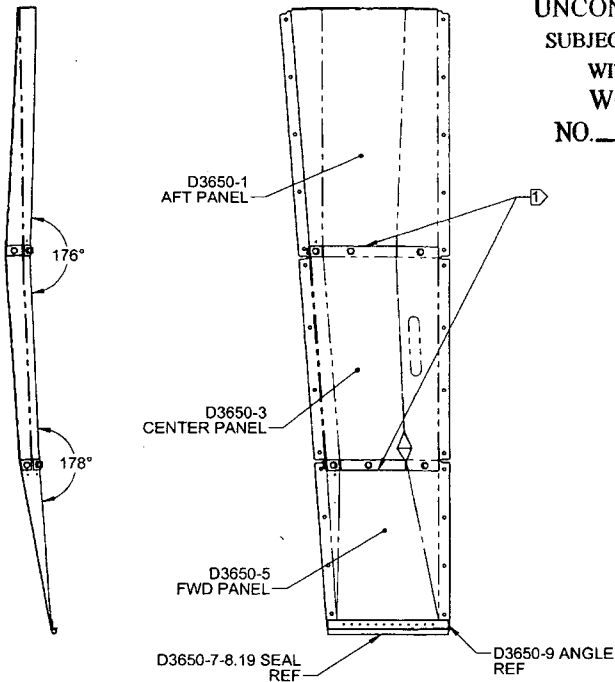
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**NOTE:** Date & initial all entries



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW  
OK  
PAR 09/08  
RELEASE  
OK  
11/17/17

### D3650-041 TUNNEL TOP PANEL ASSEMBLY

#### NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4MS WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7, B5-7, B6-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11F FROM SHEET 6; UPDATED DIMS OF D3650-11F-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3650</b> TITLE <b>TOP PANEL ASSEMBLY</b> SCALE 1:8 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	RF		
CHECKED	B		
MFG. APPR.	W		
APPROVED	W		
DE APPR.	W		
DATE	08.10.14		

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